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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D117-840-011
Job Sheet 189754



Part No: D117-840-011

Job Qty: 1 pcs

Part Name: BK117/EC145 Bearpaws with Wearplates



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/30/19

Job Tracking No:

Due Date: 2/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 13-04-01 JLM VERIED BY:DD IPP REV:B 13.05.28 PER IIN D117-840
REV.A DD VERF:JLM IPP REV:C 15.03.30 PER REV B JLM VERIFIED BY:DD IPP REV:D 16.02.23 PER IIN
REVC DD VERF:JLM

Ship Via:

007839

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
160	Packaging 1 - Pick Kit	1 pcs	2/11/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

DAS

6

9-89

JAN 31 2019

Fy015

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Re: _____ Use: _____	DEPARTMENT/PROCESS																																												
Date: _____		Sequence #: _____																																												
Description Work Order Deviation																																														
Root Cause <table style="width: 100%;"><tr><td>Operator</td><td>☐</td></tr><tr><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td></tr><tr><td>Handling/Presservation</td><td>☐</td></tr><tr><td>Material</td><td>☐</td></tr><tr><td>Product Improvement</td><td>☐</td></tr><tr><td>Process Improvement</td><td>☐</td></tr><tr><td>Human Factors</td><td>☐</td></tr></table>	Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Presservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table style="width: 100%;"><tr><td>☐ Pressure/Forced</td><td>☐ Contamination</td><td>☐ Power Loss/Surge</td><td>☐ Positioned Wrong</td></tr><tr><td>☐ Bending</td><td>☐ Misaligned/off center</td><td>☐ Folio/Program</td><td>☐ Outside Tolerance</td></tr><tr><td>☐ Crushing</td><td>☐ BOM/Route</td><td>☐ Grain Direction</td><td>☐ Drawing</td></tr><tr><td>☐ Cracks</td><td>☐ Broken/Damage/Defect</td><td>☐ Weld</td><td>☐ Finish</td></tr><tr><td>☐ Crimp/Kink/Ripple/Wave/Twist</td><td>☐ Incomplete/Unclear Instructions</td><td>☐ Wrong Stock Pulled</td><td>☐ Part Lost/Missing</td></tr><tr><td>☐ Marks/Chatter</td><td>☐ Drill Holes</td><td>☐ Out of Sequence</td><td>☐ Misread</td></tr><tr><td>☐ Mislabeled</td><td>☐ Fit/Function</td><td>☐ Off-set/Set-up</td><td></td></tr></table>		☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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Other/Details: _____																																														

DART
AEROSPACE

Container No: S149629

Part: D117 - 840 - 011

Job No: 189754

Serial No/Batch: S149629

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: TC STC SH13 - 18 - Issue, FAA/STC SR03316NY 13/07/29, EASA

Unit Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

170 QC 4	1 pcs	2/11/19	0.00 0.00	Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				QC 4 - 26	
				QC 4 - 28	
				QC 4 - 38	
				QC 4 - 42	
				QC 4 - 58	
180 Packaging 3-1 - Stock - B4B	1 pcs	2/11/19	0.00 0.00	QC 4 - 6	DAS 69 9-89
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	DAS 69 9-89
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
185 DC - 1 - B4B	1 pcs	2/11/19	0.00 0.00	Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
190 QC 21 - FG	1 pcs	2/11/19	0.00 0.00	Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
Part Op 170 - (QC4- 100% Inspect kits for completeness)				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
Descriptions: 180 - Identify and pack for shipping as per PPP D117-840-011				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
185 - Photocopy bluefile & type labels per PPP D117-840-011 CHG 003				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
190 - (QC21- Final Inspection - Work Order Release)				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
185 DC - 1 - B4B	1 pcs	2/11/19	0.00 0.00	Packaging 3 - 35 - B4B	DAS 21 9-89
				DC - 1 - B4B	JAN 3 1 2019
190 QC 21 - FG	1 pcs	2/11/19	0.00 0.00	DC - 2 - B4B	DAS 21 9-89
				QC 21 - FG - 21	JAN 3 1 2019

Part Op 170 - (QC4- 100% Inspect kits for completeness)

Descriptions: 180 - Identify and pack for shipping as per PPP D117-840-011

185 - Photocopy bluefile & type labels per PPP D117-840-011 CHG 003

190 - (QC21- Final Inspection - Work Order Release)

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :		Sequence #:		QTY Affected :		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
		Other/Details:					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4C11A	Bolt	12 Ea (12 ea)	160-Packaging 1 - Pick Kit	5098546X7 5082910
AN4C17A	Bolt	8 Ea (8 ea)	160-Packaging 1 - Pick Kit	5093740
D2274	Radius Block	8 pcs (8 ea)	160-Packaging 1 - Pick Kit	5130332
D3456-1	Washer	8 pcs (8 ea)	160-Packaging 1 - Pick Kit	509335
D4012-3	Cushion	4 pcs (4 ea)	160-Packaging 1 - Pick Kit	5046542
D5377-1	Bearpaw	2 pcs (2 ea)	160-Packaging 1 - Pick Kit	5124364
D5378-041	Bearpaw Wearplate Assembly	2 pcs (2 ea)	160-Packaging 1 - Pick Kit	5110355
D5379-1	Bearpaw Clamp	4 Ea (4 ea)	160-Packaging 1 - Pick Kit	5124348
MS21043-4	Nut	20 Ea (20 ea)	160-Packaging 1 - Pick Kit	513183214 5132395
NAS1149D0463J	Washer	12 Ea (12 ea)	160-Packaging 1 - Pick Kit	5130345

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
160-Packaging 1 - Pick Kit	AN4C11A	12	158	0
	AN4C17A	8	54	0
	D2274	8	159	0
	D3456-1	8	172	0
	D4012-3	4	49	0
	D5377-1	2	2	0
	D5378-041	2	2	0
	D5379-1	4	28	0
	MS21043-4	20	1,627	0
	NAS1149D0463J	12	2,677	0

Part Specifications

Specifications could not be found.

Plex 1/30/19 9:48 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

32.6 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-840-011 <i>Bearpaw Installation</i>	27.7 lb 12.6 kg	0.0 in 0.0 mm	0.0 lb-in 0.0 mm-kg	204.1 in 5200 mm	5653 in-lb 65,520 mm-kg

32.7 PARTS LIST (Kits @ CHG 003 and Later)

QTY -011	Part Number	Description
X	D117-840-011	BEARPAW INSTALLATION
8	D2274	RADIUS BLOCK
8	D3456-1	WASHER
4	D4012-3	CLAMP CUSHION
2	D5377-1	BEARPAW
2	D5378-041	BEARPAW WEARPLATE ASSY
4	D5379-1	BEARPAW CLAMP
12	AN4C11A	BOLT
8	AN4C17A	BOLT
20	MS21043-4	NUT
12	NAS1149D0463J	WASHER

32.8 PARTS LIST (Kits @ CHG 001 - 002)

QTY -011	Part Number	Description
X	D117-840-011	BEARPAW INSTALLATION
8	D2274	RADIUS BLOCK
12	D3456-1	WASHER
4	D4012-1	CLAMP CUSHION
2	D4796-1	BEARPAW
2	D4798-041	WEARPLATE ASSY
4	D4799-1	CLAMP
12	AN4C11A	BOLT
8	AN4C17A	BOLT
20	MS21043-4	NUT
8	NAS1149D0463J	WASHER

REFERENCE ONLY

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